

Date: Wednesday, 6/20/2007 11:21:35 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: AFT CROSSTUBE	
Job Number	: 33027		Part Number	: D2890	
Estimate Number	: 10377		Drawing Number	: D2890 REV B	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 6/20/2007 S.O. No. : N/A		Drawing Revision	: B	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 6/27/2007 Qty: 1 Um: Each	
Previous Run	: 33026				
Written By					
Checked & Approved By					
Comment	: Est. D 05.03.21 Removed Bending procedures KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6008180	Crosstube extrusion
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)		
Pick:		
Qty	Part #	Description
1	D6008-180	Crosstube extrusion
2.0	BENDING	BENDING MACHINE
Comment: BENDING MACHINE		
1-Bend D2890 as per Dwg D2890 and Folio FT002		
3.0	QC6	DIMENSIONAL CHECK
Comment: DIMENSIONAL CHECK		
4.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
Comment: LANDING GEAR RESOURCE 1		
1-Deburr and Polish		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/20/2007 11:21:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 33027

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

NIAZ

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W032943

207-06-28 ①

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207-06-29 ①

Job Completion



207-06-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

33027

Description: Crosstube Aft

Part Number:

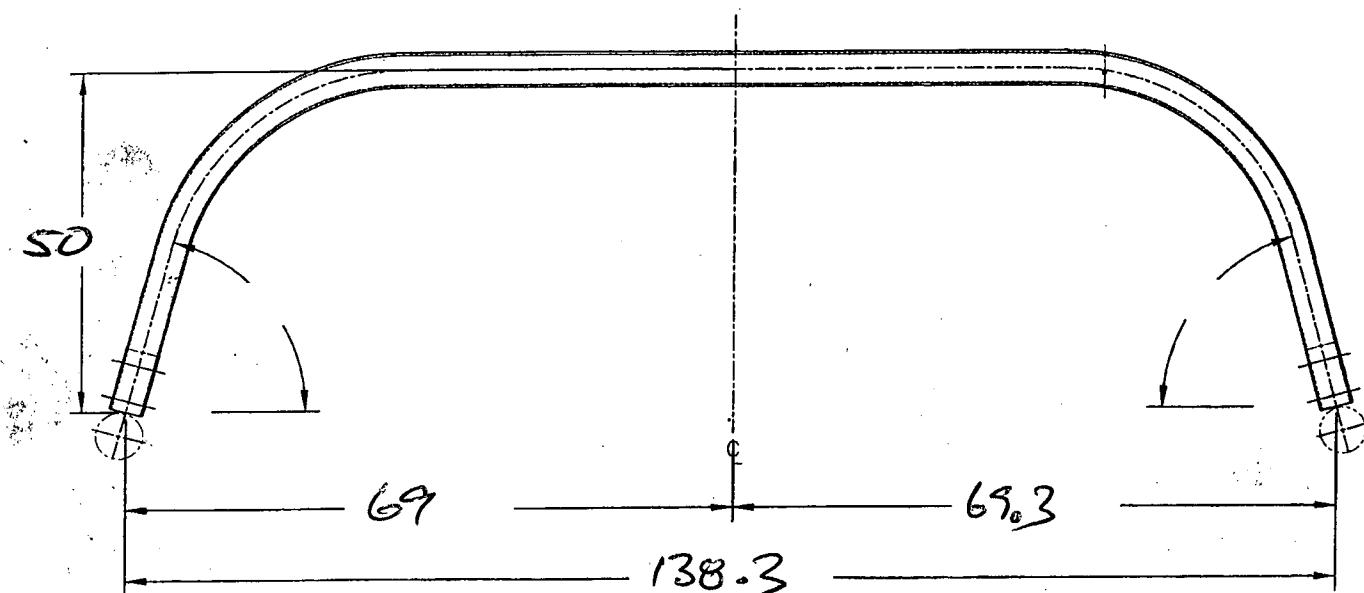
D2890

Inspection Dwg: D2890

Rev: B

Page 1 of 1

Required Dimension	Min	Max
Height	49.875	50.125
1/2 Span	69.275	69.525
Angle	49	52
Total Span	138.55	139.05



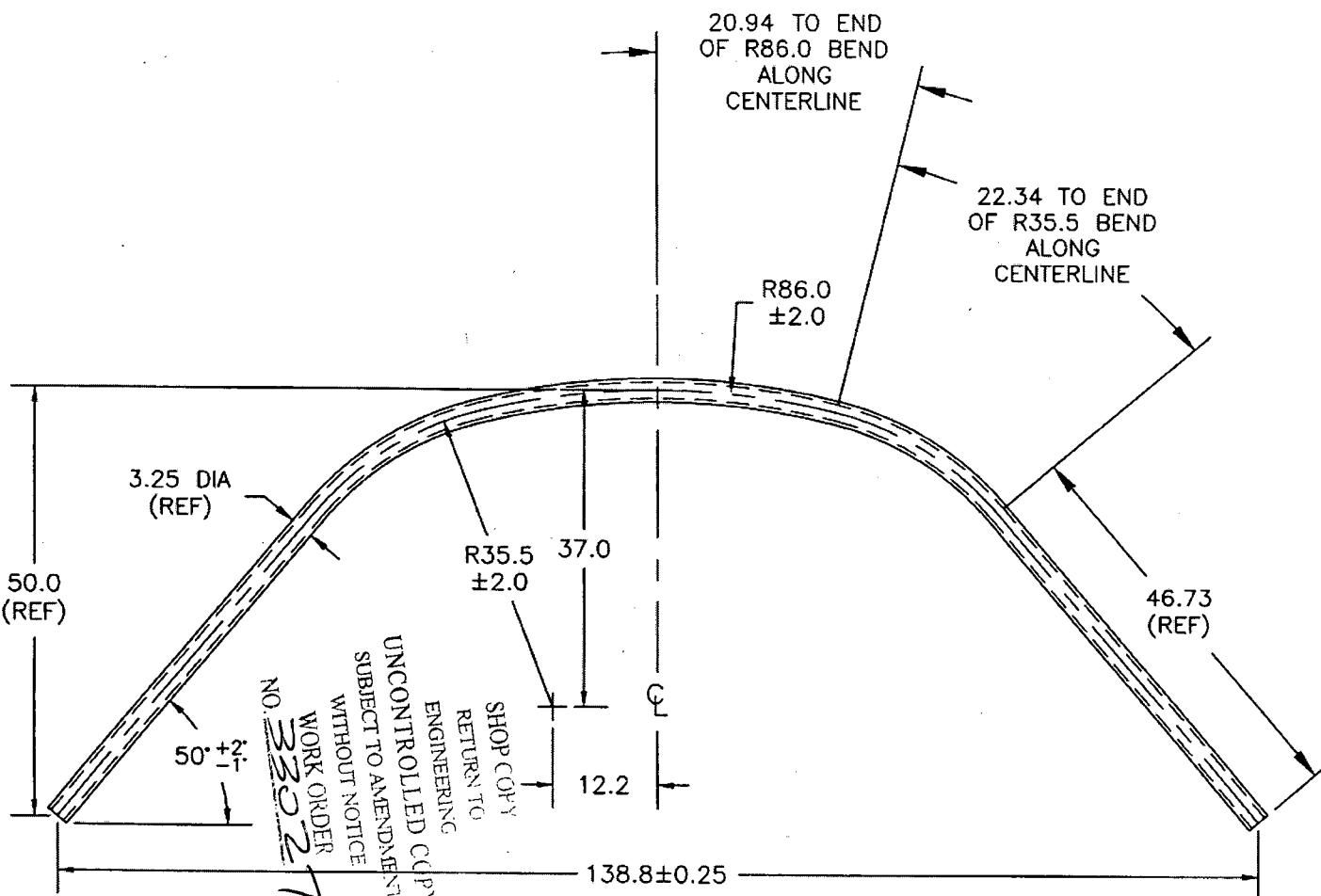
Comments
used = cut C - 103 B332943

QC15 Inspection	<i>J.051047</i>
Date	07-06-28

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM <i>[Signature]</i>	<i>[Signature]</i>

DART**RELEASED**
02-10-28

DESIGN	DRAWN BY	DART AEROSPACE LTD		
		HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. B	SHEET 1 OF 1
#	#	D2890		
DATE		TITLE		SCALE
02.10.18		AFT CROSSTUBE		1:20
A	99.05.21	NEW ISSUE		
B	02.10.18	ADD TANGENT LENGTHS; CHANGE NOTES		

NOTES

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ($\varnothing 3.25$ OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

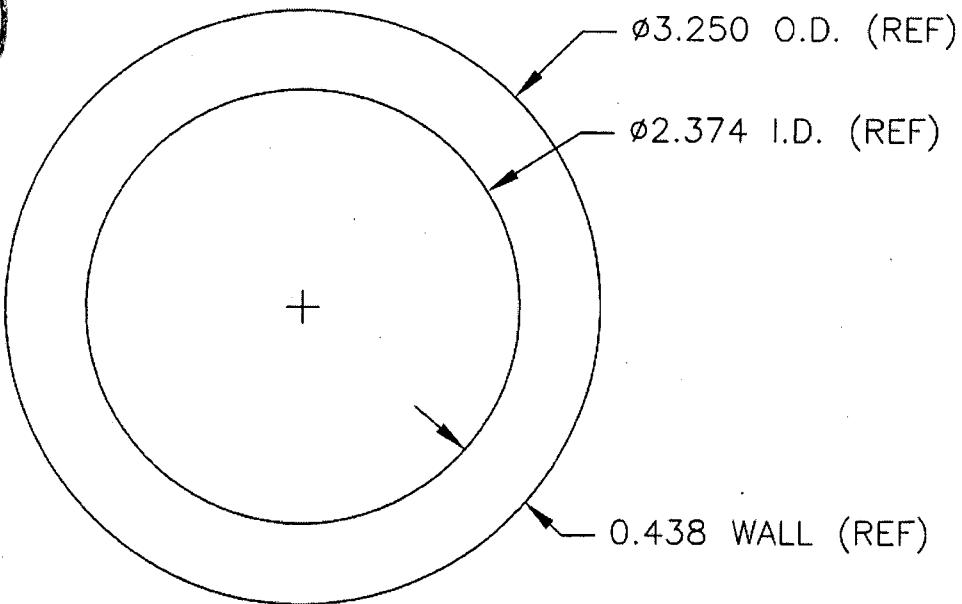


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D6008
DATE		REV. A SHEET 1 OF 1 SCALE 1:1
00.11.17		TITLE CROSSTUBE MATERIAL

A	00.11.17	NEW ISSUE
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SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24



NOTES

- 1) D6008-XXX CROSSTUBE
 LENGTH

WHERE XXX IS LENGTH IN INCHES
 EG. 180" LONG TUBE: D6008-180

- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-2257/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
 MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
 MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
 O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
 WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
 LENGTH: XXX $+0.125/-0.000$
 STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 33027